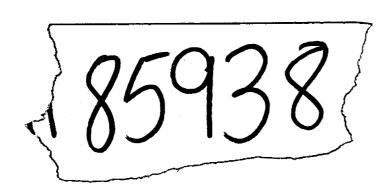
Page 1

June-19-12 7:59:05 AM

Item ID:	D350-636-0	12		Accept	*N900	0.40	100	ገ* ፡	Setup St	art *N	IS1*
Revision ID:					1 4 7 (7)	1 141		,		1.7	121
Item Name:	Skidtube RH								St	top *N	S2*
Start Date:	19/06/2012	Start Qty: 1.00	*1*		Cust Item I	D:					
Required Date:	03/07/2012	Req'd Qty: 1.00	*1*		Customer:						
Reference:			•								
Approvals:	Process Pla	in: MLJ	Date: 12/06/19	Tooling:	D:	ate:		F	Run St	art *N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			St	^{op} *N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr			-	·					
D2750	F		i								
D3492	C		×9.					,			
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DC		Memo		0.00 16	,7(4/27			-1-//	· <u> </u>		
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W/O:		WORK ORDER CH	ANGES				S	× 6
DATE	STEP	PROCEDURE CHANGE	By. Date				Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORD	ER NON-CONFORMANO	E (NCR)			
		Description of NC		Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			QC Inspector
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NR1

hung-10-12 7:50:05 AM

Item ID: Revision ID:	D350-636-0 Skidtube RH	112		Accept	*N900	040	1100) *	Setup S	tart Stop	*N.	S1*
Item Name; Start Date: Required Date Reference:	19/06/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:	ID:			3	тор	*N;	S2*
Approvals:	Process Pla	an:	Date:			ate:		I		tart top	*N *N	R1*
Sequence ID/ Work Center	ID	Operation Description Skidtubes		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp
Skidtubes Skidtubes		Memo I- Pick D26	00-3 Bent	0.00				-		<u></u>	- ' · · ·	
		AFT end pe	dwg D2750	nove bending marks. Scribe by g bolt holes using DT8983. Op								
		fitting		ing bolt holes and drill pilot ho					B	LZ	4011	1,
		6- Drill pilo	holes as per Dwg D2	ing DT9616. Ensure proper po 750 sheet 4 (D2750-2 details). side only DT8863B for second	Drill using drill					•	[]	
		7- Clecko D ***SECON	F8863B on second sid O SIDE***	e of tube and drill pilot holes t	for detail B.			/				
		8-Open up h	oles for Detail "K" to	0.375" (4 holes per side)and bl	ade fitting							

location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to

holes for ground handling and detail L to 0.500" (8 holes per side)

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

0.297".

W/O:	,			WORK (ORDER CHANGES	3			٥	
DATE	STEP		PRO	CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•		PAR #:	Fault Category: _		NCR: Yes	No DQ	A:	Date:	
	R	esolution:		Disposition: '		QA: N/C (Closed:		Date: _	

NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B	Verification	Approval						
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector				
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	Work Order ID 85938 June-19-12 7:59:05 AM			*85938*							Page 3		
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube RH			Accept	*N900	040	100)*	Setup St	art op	*N:	S1* S2*	
Start Date: Required Date Reference:	19/06/2012 : 03/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:								
Approvals:		nn:			··	ate:		·		art op	*NI *NI	R1*	
Sequence ID/ Work Center I	D	from bendir A/R Alum	2744 Cap as per Dwg D27 ig as per QSI 004 inum Rod batch: M elds flush as per Dwg D27	_	Tool ID es in bend left E 12/07/17 B 12/0	Tool#	Plan Code	Accept Qty	Reject Qty		eject umber	Insp. Stamp	
*120 *120* QC Quality Control		QC10- Inspect visual per	r QS1004- ground welds	0.00 0.00 16	7/03/17								
130 * 12 0*		QC5- Inspect part compl	eteness to step on W/O	0.00	7/03/02								

Memo

Quality Control

W/O:		WORK ORDER CHANGES				•	٠
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #· Fault Category· NC	R. Ves	No DO	۸.	Date	<u> </u>

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Page 4

June-19-12 7:59:05 AM

Item ID:

D350-636-012

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name: Skidtube RH

Required Date: 03/07/2012

19/06/2012

QC:

Start Qty: 1.00 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Date:

Date:

Tooling:

Date:

Run

SPC (Y/N):

Date: __

Stop

Work Center ID 140

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours** Tool ID

Tool # Plan Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

140

Sequence ID/

HandFinish Hand Finishing

Memo

0.00

0.00

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC Quality Control

Memo

0.00

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W/O:			WO	RK ORDER CHANG	ES		-	•	, 1			
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DATE	STEP	Description of NC			Section B Ve			Approval	Approval			
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June-19-12 7 59:05 AM

June-19-12 /.3	9:05 AM											
Item ID: Revision ID: Item Name:	D350-636-0 Skidtube RH	12		Accept	*N900	040	1100)*		Start Stop	*N *N	S1*
Start Date:	19/06/2012	Start Qty: 1.00	•	*	Cust Item I	D:					ı vı	. 7/
Required Date: Reference:	: 03/07/2012	Req'd Qty: 1.00	*1	*	Customer:							
Approvals:	Process Pla	ın:	Date:	Tooling:	Da	ite:		1		Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ite:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
160 Skidtubes		Skidtubes		0.00	_			-				
Skidtubes			up holes of Detail L and er dwg D2750.	ground handling to 0.625" (tot	al of 8 holes per							
-		2-Open u as per dw		.750" (total of 4 holes per side)				DL 12	127	/16	•	
		3-Open fl	oat holes to .500" (4 pe	r Side)					/	18		
			er holes of Detail K, L, sinstructions on sheet 9)	ground handling and float holes	s per dwg D2750							
		5-Deburr	and blow out all chips	from inside of tube								
·		6-Prepare	tube for welding, remo	ve alodine as required.	, s							
			eb D2739 in place as p kaflex-291 batch ex	er QSI 015 : <u>122/30</u> p. date: <u>13-3-14</u> — C	se 12/07/18	r						
		(welding i	pacers D3490-1, D3490 instructions on sheet 9) ninum Rod batch:	0-3 and D2743 as per dwg D27	50 & QSI004	/ .						
		9- At sect	ion AP-AP drill out x-b	olt spacer to 0.404"	SER/e7/	33						
		10-Grind	welds flush as ner Dwo	D2750 SAC (V 57 - 13							

11-Spot face ground handling holes section (total of 4 places per side) as per

12/07/23

Dart Ae	rospace	: Ltd							, .
W/O:			WOF	RK ORDER CHANGES	3			•	
DATE	STEP	PRO	CEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	·	PAR #:	Fault Catego	ory: l	NCR: Yes	No DQA	:	_ Date: _	
	R	esolution:	Disposition:		QA: N/C CI	osed:		Date: _	
NCR:		V	WORK ORDE	R NON-CONFORMAN	CE (NCR	R)			
		Description of NC	C	orrective Action Section 8	3	Verifica	tion	Approval	Approval
DATE	STEP	Section A	Initial	Action Description	Sign 8	Section		Chief Eng	QC Inspector

		WORK ORD	ER NON-CONFORMANC	E (NCR)			
	Description of NC		Corrective Action Section B		Varification	Annrovol	Annroyal
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
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Page 6

June-19-12 7:59:05 AM

Item ID:

D350-636-012

Accept

N900040100

Setup Start

Revision ID: Item Name:

Start Date:

Skidtube RH

19/06/2012

Start Qty: 1.00 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 03/07/2012

Process Plan: ____ Date:

Tooling:

Date:

Run

Date: SPC (Y/N):

Date:

Stop

Sequence ID/

Operation

Set Up/

Tool ID

Plan Code Accept

Reject Reject Insp.

Work Center ID

Description

Run Hours

Tool#

Qty

Qty

Number Stamp

dwg D2750

12-Deburr holes

QC10- Inspect visual per QSI004- ground welds

QC5- Inspect part completeness to step on W/O

0.00

170

Quality Control

Memo

0.00

180

170

180 QC

Memo

0.00

Quality Control

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W/O:			W	ORK ORDER CHANG	ES			*	2.4
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No. DQ	A :	Date: _	
	Re	esolution:	Dispositio	n: <u>'</u>	_ QA: N/C C	losed:			
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCI	₹)			
DATE	STEP	Description of NC	Corrective Action Section B Verifica				cation		Approval
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W/O:			WC	ORK ORDER CHANGES					•
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Part No):	PAR #:	Fault Cate	gory: h	ICR: Yes	No DQ	A :	Date: _	
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	STEP	Description of NC	WORK ORDI	ER NON-CONFORMANC Corrective Action Section E Action Description	CE (NC	R) Verifi	cation	Approval	Approval
	STEP	Description of NC	WORK ORDI	ER NON-CONFORMANC Corrective Action Section E Action Description	CE (NC	R) Verifi	cation	Approval	Approval
	STEP	Description of NC	WORK ORDI	ER NON-CONFORMANC Corrective Action Section E Action Description	CE (NC	R) Verifi	cation	Approval	Approva
	STEP	Description of NC	WORK ORDI	ER NON-CONFORMANC Corrective Action Section E Action Description	CE (NC	R) Verifi	cation	Approval	Approval QC Inspecto
	STEP	Description of NC	WORK ORDI	ER NON-CONFORMANC Corrective Action Section E Action Description	CE (NC	R) Verifi	cation	Approval	Approval QC Inspecto

Page 8

June-19-12 7:59:05 AM Item ID: D350-636-012 Accept *N900040100* Setup Start **Revision ID:** Skidtube RH Item Name: **Start Date:** 19/06/2012 Start Qty: 1.00 Cust Item ID: **Required Date:** 03/07/2012 Reg'd Oty: 1.00 **Customer:** Reference: Run Approvals: **Process Plan:** Date: Tooling: Date: Stop Date:_____ SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool ID Tool# Reject Plan Accept Reject Insp. Work Center ID Description Qty Qty Run Hours Code Number Stamp 230 0.00 HandFinishing *230* HandFinish 0.00 Memo Hand Finishing 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Spray inside of tube with "LPS-3" batch: N/A 4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 122 136 EXP DATE: 14/07 5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 110348

6-Coat all exposed fasteners with "LPS Procyon"

batch: 114596

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W/O:			ORK ORDER CHANGE	ES			· <u>-</u>	•		
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No	•	PAR #:	Fault Cat	degory:	NCR: Ye	s No	DQ	A:	Date:	
		esolution:								
NCR:		\	WORK ORI	DER NON-CONFORMA	NCE (NO	CR)	4. 18.80			
DATE	STEP	Description of NC			ection B			Verification		Approval
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Work Orde June-19-12 7:59	er ID 85	938			85	938*	·		77.7	er a 157 tea		:	Page 9
Revision ID: Item Name:	D350-636-0 Skidtube RH 19/06/2012	12 Start Qty: 1.00	*1*	Accept			00040	10	N *	Setup	Star Stop	1 7	S1* S2*
Required Date: Reference:		Req'd Qty: 1.00	*1*			Cust Ite Custom							
Approvals:	Process Pla		Date:	Tooling SPC (Y/			Date:			Run	Star Stop	171	R1* R2*
Sequence ID/ Work Center II 240 *740* QC Quality Control)	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set U Run 0.00	Hours AS 16	Tool I	D Tool#	Plan Code	Accept Qty	t Re Qt	ject y	Reject Number	Insp. Stamp
250 *250* Packaging Packaging		Pick Kit Memo		0.00					LX				-P

260

QC4- 100% Inspect kits for completeness

260

Memo

Quality Control

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W/O:			W	ORK ORDER CHANGE	S			•	4.7		
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No		PAR #:	Fault Cat	egory:	NCR: Yes	Date:					
	R	esolution:	Dispositi	isposition: QA: N/C Closed: I							
NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC	Initial	Corrective Action Section	n B			erification Approval			
		Section A	Chief Eng	Action Description Chief Eng	Date	Section	on C	Chief Eng	QC Inspector		
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Work Ord June-19-12 7:	der ID 8593 59:05 AM	38		*859	, , , ,							Page 10
Item ID: Revision ID: Item Name:	D350-636-012 Skidtube RH	· · · · · · · · · · · · · · · · · · ·		Accept	*N900)040	100)*	Setup	Start Stop	*N.	S1* S2*
Start Date: Required Date Reference:		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:						I W	. 1/
Approvals:	Process Plan:		Date:	Tooling: SPC (Y/N):		Date:	·		Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center 270		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
* 77 0* Packaging Packaging	P	Packaging Memo	per PPP D350-636-012	0.00					1) ———	

0.00

0.00

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QC21- Final Inspection - Work Order Release

Memo

280

280

Quality Control

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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	\ :	Date: _	
	Res	solution:	Disposition	ı: <u>'</u>	_ QA: N/C Cld	sed:		Date: _	
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Picklist Print

June-19-12 7:59:09 AM

Work Order ID: 85938

85938

D350-636-012

Parent Item Name: Skidtube RH

D350-636-012

Start Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

Required Date: 03/07/2012

Page 1

Comments:

Parent Item:

IPP Rev:102.09.25Rearranged procedure stepsKJ

IPP Rev:J 06-03-29

As per Rev D

EC

IPP Rev:K 06-07.13 IPP Rev:L 07-07-28

As per dsi9343

Added SS Wearplates(Rev E) JLM Verified By:EC

IPP Rev:M 08-04-22

update steps 4,13 DD verified by:EC

IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec

IPP Rev:O

10.06.22 revise seq110 DD verf:EC

IPP Rev:P 10.10.01 as

per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	23.0000	1	 1			
D2600-3-	RFNT								**	(1)	B	7/05/1	<u>-</u>
				Location	$\left(\mathbf{g}_{1,222}\right)$	Loc	<u>Qty</u>	Loc Code					
				LG (86330		23		_	<u>,</u>	_		
					66875		7		_		_		
					73253		1		_		_		
					75021		1				_		
					75022		1			_			
					75023		1				_		
					81330		4		_				
					83305		1				_		
					83442		7		_		-		
D2744		Manufactured	No			110	Each	68.0000	1	1	_		
D2744					·				**			BK 12/0	7/17

Location Loc Oty Loc Code LG002 68 62715 83412 29 85506 38

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Part No	:	PAR #:	Fault Cat	egory:	NCR:	Yes N	lo DQ	A :	_ Date: _	
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NCR:		•	WORK ORD	DER NON-CONFORM	IANCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	ction B	Sign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector
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Picklist Print June-19-12 7:59:09 AM				·		·		٠	Page 2
Work Order ID: 85938		*Q	5938*						
Parent Item: D350-636-012 Parent Item Name: Skidtube RH			350-636-01			art Date:	19/06/2012 1.00	Required Date: 03/07/2012 Required Qty: 1.00	
D2739 *D2739* 350 1 Beam	Manufactured	No		160	Each	0000.11	\ * *	1 OC 12	2/67/18
			Location B 8643 LG 72155 81508 83447 83448 83548	7 1	11 1 1 3 4 2	Loc Code		6	- - - -
D2743 *D2743* Crossbolt Spacer	Manufactured	No	65346	160	2 Each	256.0000	8 **	8	3E12/07/23
			Location LG 81965 83262 LG001 67766 68251 73403 74445 79517	<u>l</u>	182 55 127 74 4 3 64 1	<u>Loc Code</u>			\$65459 '& B - - - - - - -
D3490-3 *D3490-3* Cross Bolt Spacer	Manufactured	No	,,,,,,,	160	Each	102.0000	4 **	4	B.C12/07/23
•			LG001 83313 85420	<u>L</u>	oc Qty 102 42 60	Loc Code			· / - -

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W/O:			WC	RK ORDER CHANGI	ES			¢.	* *
DATE	STEP	PRO	PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr Al Chief E	Approval QC Inspector					
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	Resolution:								
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Picklist Print June-19-12 7:59:09 AM			. · · ·							Page 3
Work Order ID: 85938		*25	5938*							
Parent Item: D350-636-012 Parent Item Name: Skidtube RH			350-636-0	12*			art Date: 1		_	l Date: 03/07/2012
D3490-1							tart Qty: 1		Require	d Qty: 1.00
D3490-1 Cross Bolt Spacer	Manufactured	No		160	Each	111.0000	4 **	4	£	4E12/07/23
D3631-1 *D3631-1* Washer	Manufactured	No	Location LG 81976 85419 LG001 62450 74875 77042 83269	<u>Lo</u> 230	88 2 86 23 2 4 3 14 Each	Loc Code 331.0000	8 **	8	 	12/07/25
 D3791-1	Manufactured	No	Location FG 81874 83588 ST072 68062 75548	<u>Lo</u> 230	2 314 15 2 13 Each	<u>Loc Code</u> 29.0000	ı		 	, ,
D3791-1	rranaractared			250	Lucii		**)	(SP)	12/07/25

Wearplate

	12	· 							•
W/O:		·	WO	RK ORDER CHANGI	ES			•	
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								:	
Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQA	:	_ Date: _	
Resolution: Disposition: QA: N/C Closed:								Date:	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Initial					Approval	Approval
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Picklist Print June-19-12 7:59:09 AM	•		_		· •			-	·		Page 4
Work Order ID: 85938		*A	5938	*							
Parent Item: D350-636-012 Parent Item Name: Skidtube RH				636-0	12*				0/0//0010		
arene real Name. Oxidable Riv								tart Date: 1 Start Qty: 1			Date: 03/07/2012 d Qty: 1.00
D3793-3	Manufactured	No			230	Each	28.0000	1	1		
D3793-3 Wearshoe								**			12/07/25
			Location	1	<u>La</u>	oc Qty	Loc Code			_	·
			FP001	/		28					
				83394		16				_	
MS21043-6	Purchased	No		83901	230	12 Each	610.0000	4		_	
MS21043-6	Talonasca				250	Zacii	010.0000	**	4 <u>Y</u>		12/07/25
			Location	ļ	<u>Lo</u>	c Qty	Loc Code				
			FG			20					
				103693		20				_	
			ST301	117887		590				_ ·	
				11/88/		2 88				_	
				120308		500				_	

230

D3794-1

Manufactured

D3794-1

Location Loc Oty Loc Code FP 82167 FP002 20 83395 V 20

Each

26.0000

**

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W/O:			WC	RK ORDER CHANGE	S			*	
DATE	STEP	PRO	OCEDURE CHA	NGE	By Date Qty A NCR: Yes No DQA: QA: N/C Closed: RMANCE (NCR) Section B tion Sign & Verification Section C	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	Re								
	}								
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _	
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June-19-12 7:59:09 AM

Work Order ID: 85938

Parent Item:

D350-636-012

Parent Item Name: Skidtube RH

85938

D350-636-012

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

164.0000

**

NAS1611-010	
O-RING	

Locatio	<u>n</u>	<u>Lo</u>	c Oty	Loc Code
FP001	122151		164	
	110915		14	
	117460		8	
	118077		1	
	118612		3	
	119438		47	
	121259		2	
	121584		39	
	121723		50	
		250	Each	47.0000

Blade, 350 Skidtube

Manufactured

**

Location	Loc Qty	Loc Code
ST	-10	
ST466	57	
71856	1	
79516	7	
83135	39	

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W/O:			WO	RK ORDER CHANGES			···· · · · · · · · · · · · · · · · · ·	•	• •
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	sed:	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			· · · · · · · · · · · · · · · · · · ·						
Part No	<u> </u>	ΡΔR #·	Fault Cated	lorv.	ICR: Yes	No DO	Δ-	Date:	
NCR:		•	WORK ORDE	R NON-CONFORMAN	CE (NCR	1)	· ·		
DATE	R:	Description of NC	<u> </u>					Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	By Date Qty Chie Pro NCR: Yes No DQA: Chie Pro QA: N/C Closed: Chie Pro WANCE (NCR) ection B Verification App	Chief Eng	QC Inspector		
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Work Order ID: 85938		*8	5938	8*							·· <u></u>
Parent Item: D350-636-012		*[350	-636-0°	12*						
Parent Item Name: Skidtube RH			,,,,,,,	(7,7,7,7,7,7,7,7,7,7,7,7,7,7,7,7,7,7,7,	. ,			art Date: tart Qty:			red Date: 03/07/2012 rired Qty: 1.00
NAS1515H3L	Purchased	No			230	Each	138.0000	4	4		
*NAS1515H3I *								**	4.		12/07/25
			Location	<u>on</u>	<u>Lo</u>	oc Qty	Loc Code				
			FG	1221514		40					
				102472		40					
			ST277			98					
				118686		3					
				119438 120360]					
				120300		11 2					
				121556		81					
NAS1611-013	Purchased	No			230	Each	341.0000	8	8		
NAS1611-013								**	8	D	12/07/25
			Locatio	<u>on</u>	Lo	c Qty	Loc Code				
			FP001			341					
				116582		5					
				117291		2					

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										1
W/O:			W	ORK ORDER CHANG	ES				•	•••
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE STER										
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Y	es N	o DQ	A :	Date:	
			ition: Disposition: QA: N/C Closed: Date: _							
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC					Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng			Secti	on C	Chief Eng	QC Inspector
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•				ORDER NON-CONFORMANCE (NCR) Corrective Action Section B Action Description Sign & Section C						

Picklist Print June-19-12 7:59:10 AM										Page 7
Work Order ID: 85938		*85938	ς*		•					
Parent Item: D350-636-012			-636-0	4 O*						
Parent Item Name: Skidtube RH		~し.350	-n.3n-()	17"				0.10.6.10.01.0		
a cut item Name. Skidude Kii					Start Date: 19/06/2012			Required Date: 03/07/2012		
						5	Start Qty: 1	.00	Requi	red Qty: 1.00
AN3C6A Purch	nased	No		230	Each	359.0000	4	4		
AN3C6A							**	4		12/07/25
		Locatio	<u>on</u>	Le	oc Qty	Loc Code				·
		FP001		·	1					
			111982		1					
		ST351			358			-		
			111982		2					
			116419		23					
			116549		2					
			116704		12					
			117619		10				***	
			117688		1					
			117872		5					
		- "04.	118422		13					
			119449		21			-		
			120423 120693		3 126					
			121682		140			~~~		
NAS1149C0832R Purch	ased N	No	121002	230	Each	256.0000	1	1		
	ascu .			230	Lucii	230.0000	alasta	I		, ,
NAS1149C0832R							**			12/07/25
		<u>Locatio</u>	<u>n</u>	<u>Lo</u>	c Qty	Loc Code				
		ST297	/		256					
			114915		256					
D3536-25 Manu	factured N	No		230	Each	28.0000	1	1		
D3536-25							**			12/07/25
		Locatio	n	Lo	c Qty	Loc Code				•
		FP	_		28					
		••	83391		12					

16

83900 🗸

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W/O:			WC	RK ORDER CHANG	ES		· · · · · · · · · ·	•	
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		esolution:							
NCR:			WORK ORDI	R NON-CONFORM	ANCE (NCR)			
DATE	STED	Description of NC Section A		ion B	Verific	ation	Approval	Approval	
DATE ST	JILI		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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June-19-12 7:59:10 AM

Work Order ID: 85938

Parent Item:

D350-636-012

Parent Item Name: Skidtube RH

85938 *D350-636-012*

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

D3794-3

Manufactured

Purchased

No

230

Each

23.0000

Loc Code

**

**

AN3C5A

AN3C5A

Location Loc Qty FP 21 83396 V 21 FP002 2 74530 2 230 Each

1,228.000

34

Locatio	<u>n</u>	Loc Qty	Loc Code	
FP001	122141	7		
	115835	7		
ST350		1221		
	116419	28		
	117343	13		
	117764	7		
	117872	2		
	119749	23		
	120423	28		
•	121068	12		
	121255	500		
	121444	108		
	121708	500		

W/O:			WC	ORK ORDER CHANGE	ES			•	
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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		esolution:	Dispositio	QA: N/C Closed:			Date:		
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP Description of NC			on B	Verificat		Approval	Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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P	i	c	k	lis	st	P	r	in	t

June-19-12 7:59:10 AM

Work Order ID: 85938

85938

Parent Item:

D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

D3537-1

Wearpad

Manufactured No 230

Loc Qty

49

6

Each

Each

65.0000

Loc Code

**

D3535-25

Wearshoe

Manufactured

Manufactured

No

84091 230

34.0000

**

12/07/25

D3492-3

Plug

Location Loc Oty Loc Code FP001 62233 81357 82156 17 83387 83899~ 13 230

163.0000 Each

**

Location

81967 83099 83529

Loc Code

Dart Ae	rospace	e Ltd							•
W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	<u></u>								
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	Vo DQ	A :	_ Date: _	
Resolution:			Disposition	1: <u>'</u>	QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORDI	R NON-CONFORMA	NCE (NCR)			· ·
DATE	STEP	Description of NC			Section B Ver			Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
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June-19-12 7:59:10 AM

Work Order ID: 85938

Parent Item:

D350-636-012

Parent Item Name: Skidtube RH

AN960C10L

NAS1149C0332 Purchased

D350-636-012

1220634

85938

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

21.0000 . 38

*AN960C10I *

D3488-042

Manufactured

ALS4-1032-225

No

Purchased

AI S4-1032-225

Insert

Location	Lo	oc Qty	Loc Code				•
ST		21					
107534		21					
	230	Each	0.0000	1	1		
83417				**	1	P	12/07/25
	230	Each	663.0000	38	38		
				**	38	(P)	12/07/25

Locatio		Loc Oty	Loc Code	
ST281	122290	640		
	108696	146		-
	110768	62		
	118386	55		
	118966	68		
	121269	309		
ST282		23		
	120410	10		
	120451	13		

Each

									•							
W/O:			WO	RK ORDER CHANG	ES											
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
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					i-											
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A :	Date:								
		solution:	Disposition): <u>'</u>	_ QA: N/C C	losed:		Date: _								
NCR:		,	WORK ORDER NON-CONFORMANCE (NCR) Corrective Action Section B													
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Work Order ID: 85938			5938									
Parent Item: D350-636-012 Parent Item Name: Skidtube RH		*D	350-	-636-0	12*			tart Date: 1 Start Qty: 1		=	ed Date: 03/07/	/2012
D3492-1	Manufactured	No			230	Each	253.0000		8			
D3492-1								**	8	@	12/07	125
			Location	<u>n</u>	<u>Lo</u>	e Oty	Loc Code					
			FP002	69531		238 8						
				74444		2						
				76235 83259		4 224			ALEXANDER OF THE SECTION OF THE SECT			
	ï		FP-A	03237		15				• ,		
				83098		15						
D3793-1	Manufactured	No			230	Each	28.0000	1	1			
D3793-1 Wearshoe								**		(2P)	12/0=	7/25
			<u>Location</u>	<u>n</u>	<u>Lo</u>	c Qty	Loc Code					
			FP001	82171		28 2						
				83393		13			- 118			
				83903		13						
*AN8C35A *AN8C35A*	Purchased	No			230	Each	66.0000	1 **	1		12/07	125
			Location	<u>n</u>	<u>Lo</u>	c Qty	Loc Code					
			FP002			65						
				115960 118286		1 14						
				121275		50			****			
			ST346			1						
				114442 115188		0 0						
				115166		1						

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W/O:			WC	RK ORDER CHANGE	ES			4	
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
,		PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr PAR #: Fault Category: NCR: Yes No DQA: Date: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) Description of NC Corrective Action Section B Verification Approval Approva							
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes				
NCR:		V	WORK ORDE	ER NON-CONFORMA	NCE (NCR)			
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June-19-12 7:59:10 AM

Work Order ID: 85938

Parent Item:

D350-636-012

Parent Item Name: Skidtube RH

85938 *D350-636-012*

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

MS21083C8

Purchased

Manufactured

No

No

230

Each

67.0000

**

Location	Loc	: Qty	Loc Code			
304		62				
121185		27				
121349		35				
FP002		1				
115884		1				
ST303		4				
115884		0				
118077		i				
119309		2				
119638		1				
	230	Each	306.0000	8	8	
					_	

D2745

D2745

Bushing

Location Loc Qty Loc Code FP 206 79518 6 85416 200 FP001 100 69529 1 76142

98

83260

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W/O:			WO	RK ORDER CHANGI	ES	· · · · · · · · · · · · · · · · · · ·		*	
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Part No	:	PAR #:	Fault Cate	jory:	NCR: Yes	No DQ	A:	_ Date: _	
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NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	<u> </u>	Corrective Action Section		Verific	cation	Approval	Approval
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Picklist Print June-19-12 7:59:11 AM											Page 13
Work Order ID: 85938	· - · · · · ·	*Q	5938*								
Parent Item: D350-636-012 Parent Item Name: Skidtube RH			350-6		12*			tart Date: Start Qty:	19/06/2012 1.00		d Date: 03/07/2012
AN6C44A	Purchased	No			230	Each	78.0000	4	4		
AN6C44A								**	4		12/07/25
			Location 1	77761 /	Lo	c Oty	Loc Code				
				22204/		2				_	
				3964		2				-	
			ST343	1012		76				-	
		•		1013 1167		11 8				-	
				1440		50			10.	_	
			12	1689		7				_	•
D3532-1	Manufactured	No			250	Each	30.0000	2	2		
D3532-1								**	&	P	
			Location		Lo	c Oty	Loc Code		_		
			ST053			30					
				041		5				_	
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MS21083C8	Purchased	No	-		250	Each	67.0000	2	2		
)*MS21083C8*								**	$-\infty$	197	27-26.
			Location		Lo	c Oty	Loc Code)	2-7-X0
			304			62				_	
				1185		27				_	
				1349		35				_	
			FP002	E 0 0 A		1			- market a	_	
			ST303	5884		1				_	
				5884		0				-	
				8077		I				_	
				9309		2				-	
			119	9638		1				_	
June-19-12 7:59:11 AM				Shop Pack	ket Print						Page 13

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DATE	STEP	Description of NC			tion B	Verific	ation	Approval	Approval					
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	on C	Chief Eng	QC Inspector					
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June-19-12 7:59:11 AM

Work Order ID: 85938

D350-636-012

Parent Item Name: Skidtube RH

85938

D350-636-012

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Parent Item:

Purchased

No

250

Each

239.0000

Loc Code

NAS1149D0863.I

Manufactured No

Purchased

Location Loc Qty ST298 239 118078 34 119307 5 120308 100 121556 100 250

Each

Loc Qty

45

3

42

115.0000

Loc Code

**

IAN8C21A

AN8C21A BOLT

No

Location

118758

121275

ST343

Location Loc Qty ST050 115 77573 82023 14 83097 100 250 Each

45.0000 **

Loc Code

Dai t Ac	ospace	Lu						_		•			
W/O:			V	VORK ORDER CHA	ANGES				•	p ż			
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
			•				·····						
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	Resolution:												
NCR:			WORK ORDER NON-CONFORMANCE (NCR) Corrective Action Section B										
DATE	STEP	Description of NC		Section B	· · · · · · · · · · · · · · · · · · ·			ication Approval	Approval				
DATE	SIEP	Section A	Initial Chief Eng	Action Descript	tion	Sign & Date		on C	Chief Eng	QC Inspector			
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QTY | QTY | QTY -042 | -043 | -044 PART NUMBER DESCRIPTION -041 X D2750-041 350 SKIDTUBE ASSEMBLY LH D2750-042 350 SKIDTUBE ASSEMBLY, RH D2750-043 350 SKIDTUBE ASSEMBLY, LH X D2750-044 350 SKIDTUBE ASSEMBLY, RH D2739 WEB 8 8 - 8 8 D2743 SPACER 1 1 D2744 CAP D2745 8 8 BUSHING D2750-1 SKIDTUBE WELDMENT, LH D2750-2 SKIDTUBE WELDMENT, RH D2750-3 SKIDTUBE WELDMENT, LH D2750-4 SKIDTUBE WELDMENT, RH D3488-041 BLADE FITTING, LH D3488-042 BLADE FITTING, RH D3490-1 SPACER 4 4 D3490-3 SPACER 4 4 D3490-5 SPACER D3492-041 PLUG ASSEMBLY 8 8 8 8 - 8 D3492-043 PLUG ASSEMBLY 8 D3492-045 PLUG ASSEMBLY 1 D3535-25 WEARSHOE 1 1 D3536-25 GASKET 3 3 3 D3537-1 WEARPAD 8 8 -8 8 D3631-1 WASHER D3791-1 WEARPLATE 1 1 D3793-1 WEARSHOE D3793-3 WEARSHOE Æ 1 D3794-1 1 1 GASKET 1 1 D3794-3 GASKET INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) 38 38 38 38 ALS4-1032-225 /F\-34 34 34 34 AN3C5A BOLT 4 4 AN3C6A 4 4 BOLT 4 4 4 4 AN6C44A BOLT 1 1 1 AN8C35A BOL T 38 38 38 38 AN960C10 WASHER Æ-1 AN960C816I WASHER 4 4 MS21043-6 4 4 NUT 1 MS21083C8 NUT 4 4 4 NAS1515H3L WASHER

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. -85938 MCJ 12/06/19

GENERAL NOTES:

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MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).

H: ACID ETCH, ALONDE ASSEMBLY PER DART OSI 005 4.1 PRIOR TO INSTALLING D2739 WEB. POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).

TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED UNITS: INCHES UNLESS OTHERWISE NOTED BREAK SHARP EDGES: N/A

IDENTIFICATION: N/A

WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS

WELD PER DART QSI 004

INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS

INSTALL ALS-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 1- SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:

MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF

POWDER COATING WITH MEK DEGREASER

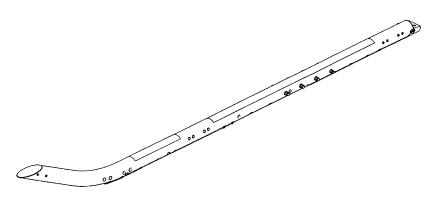
SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL F
SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

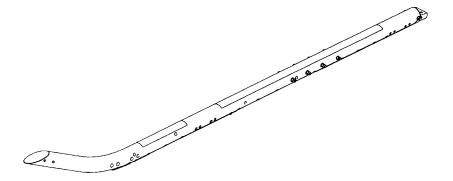
	OTY (3) D3537-1 WAS OTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1);		
F	ADD 03791-1 (ZN C&-1); WEARSHOE HOLES UNDER FWDIART SADDLE REMOVED (8 PL), WEARSHOE HARDWARE OTY UPDATED (ZN B8-1); D3488-0417-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON. REF. NCR 03-05.	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES: ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS151913, REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C9	СВ	07.05.17
D	ADD HOLES AND SHACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
С	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
В	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
Α	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE

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D2750-041 350 SKIDTUBE ASSEMBLY, LH

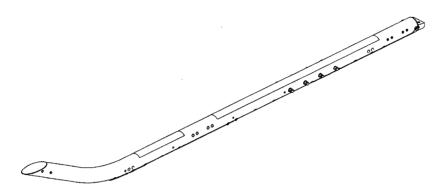
D2750-042 350 SKIDTUBE ASSEMBLY, RH

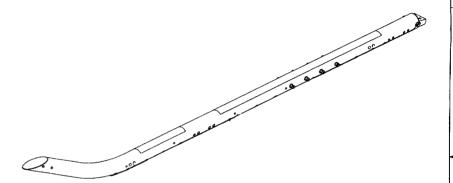


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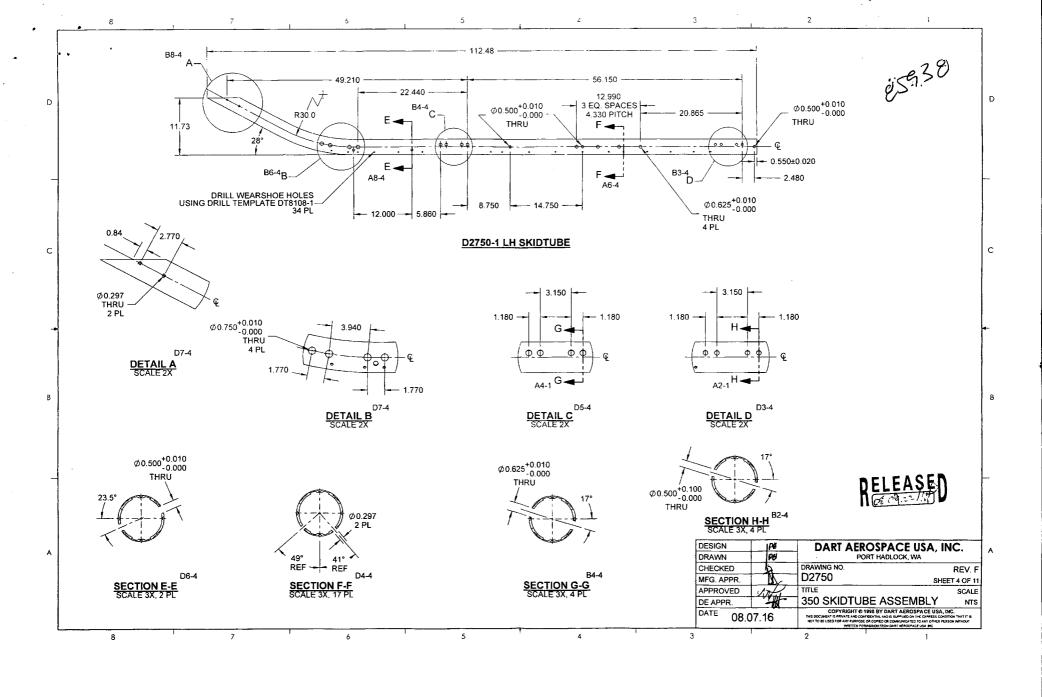
D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

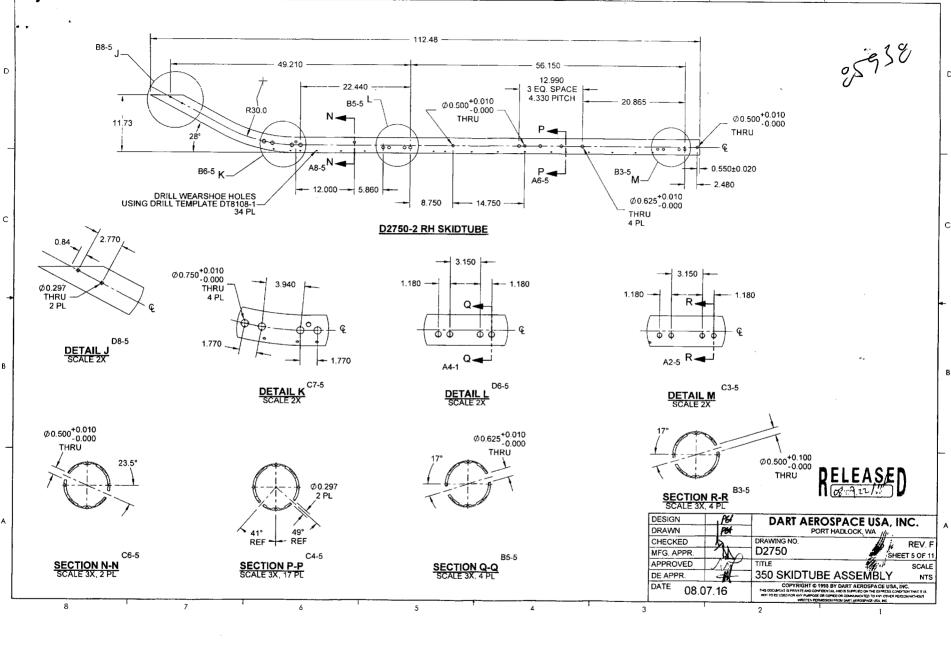
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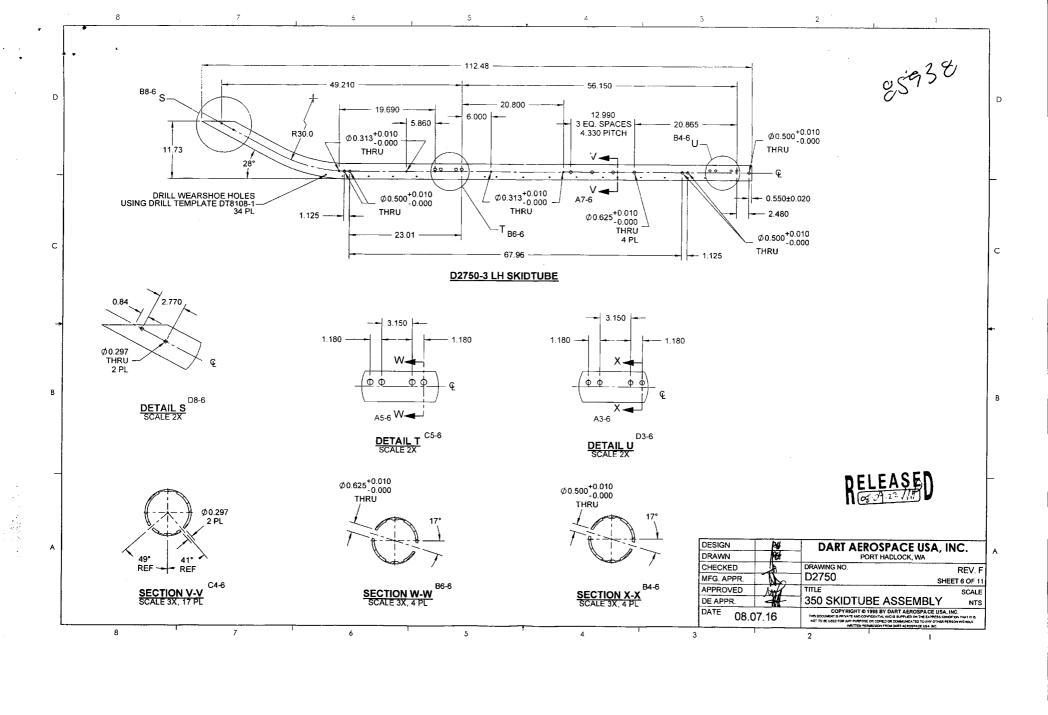
									
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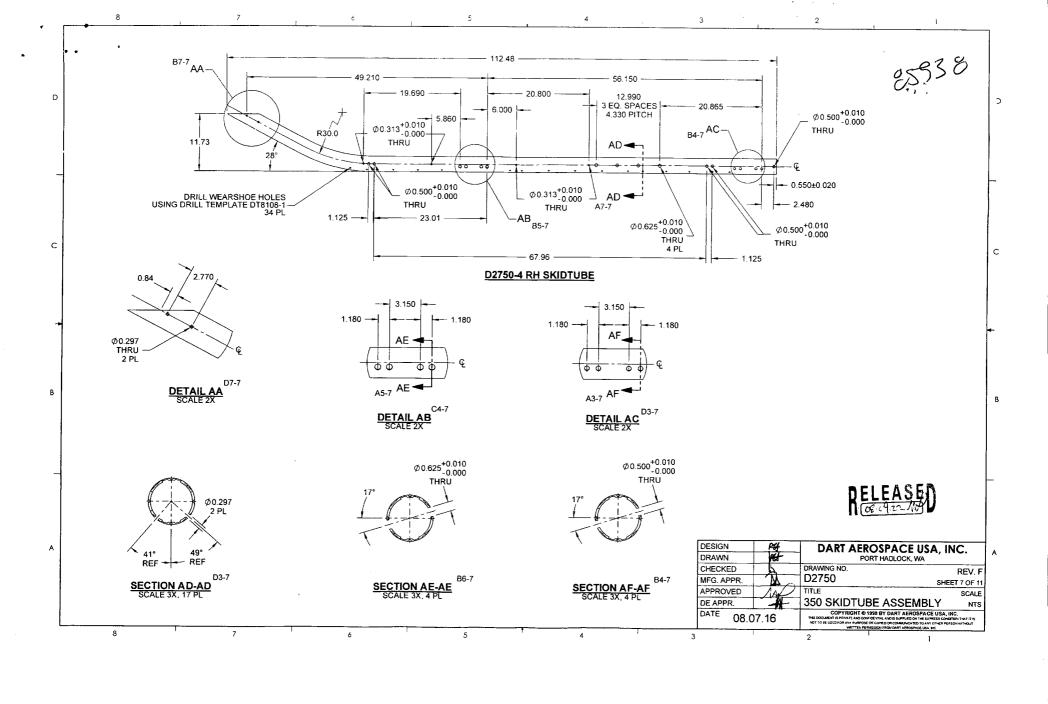
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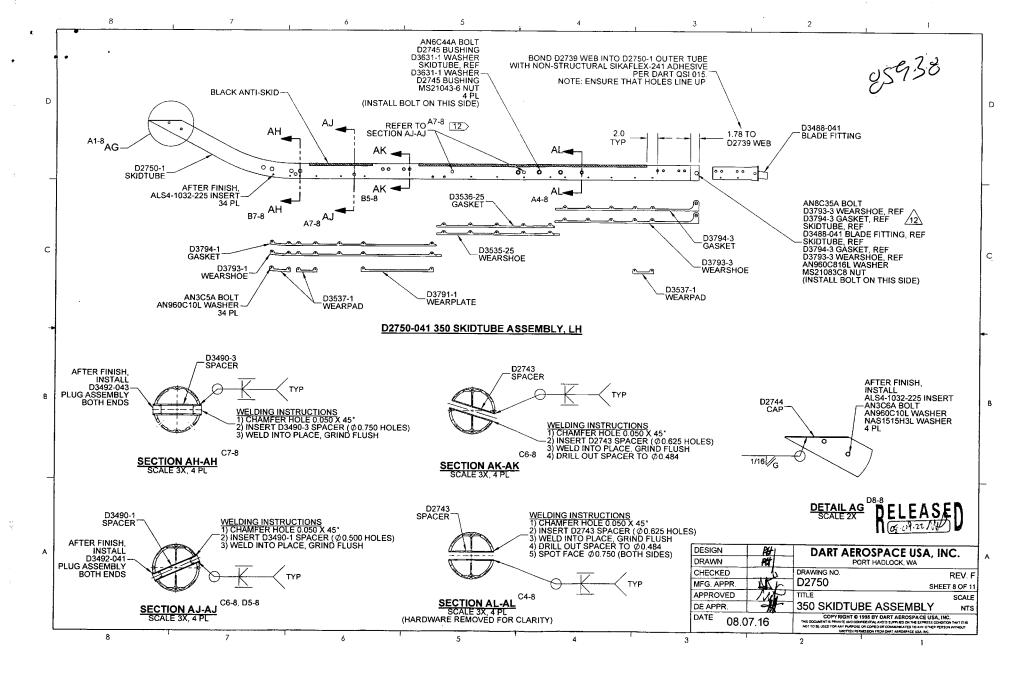
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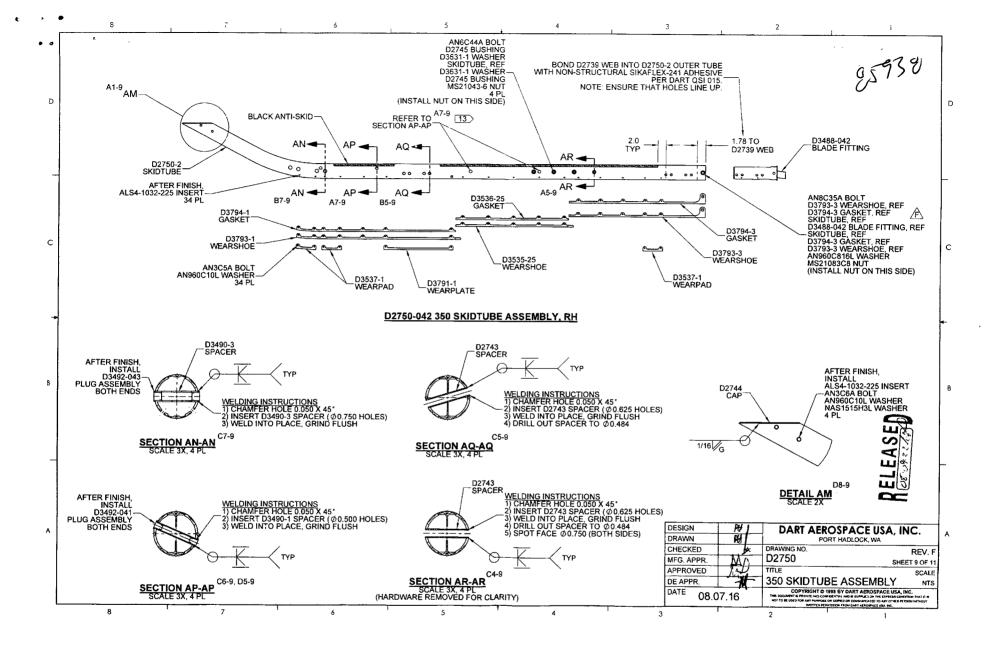
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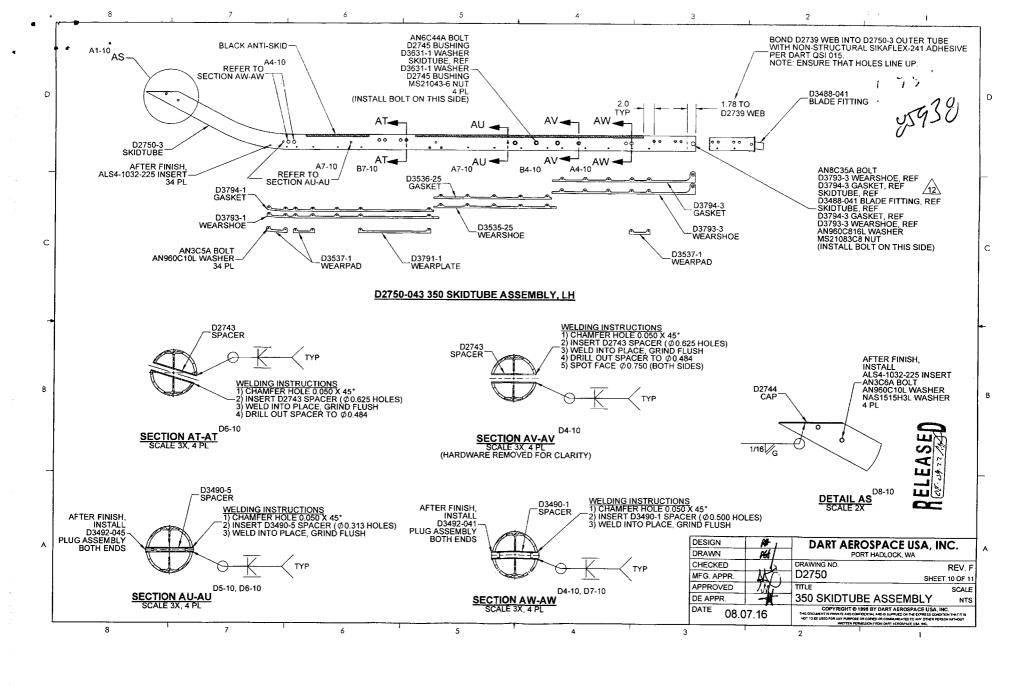
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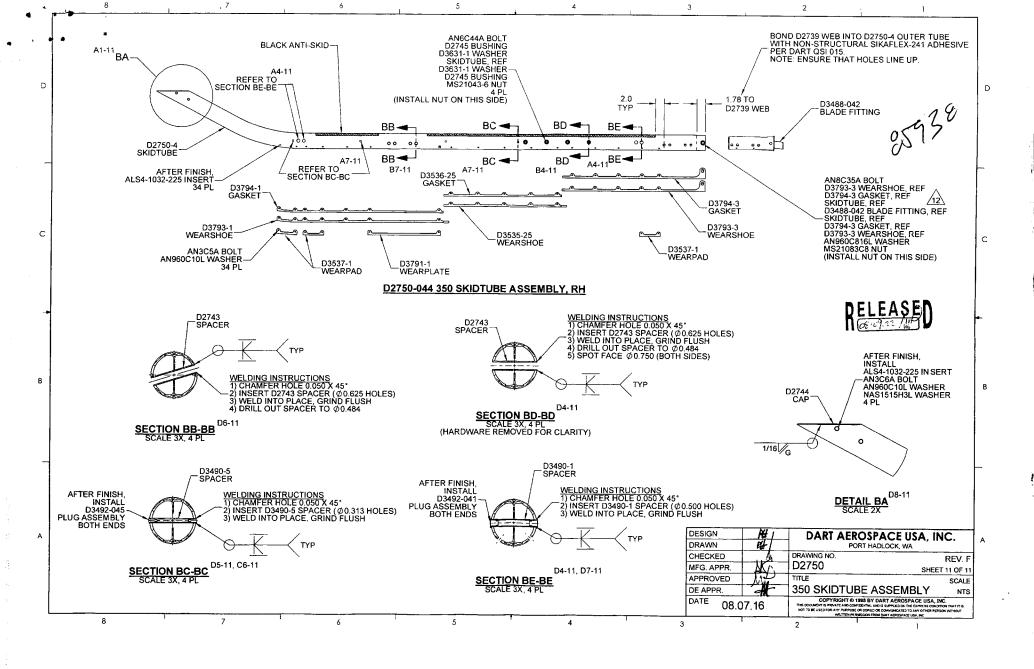


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NO. 298

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Roycley Elliott	
Job#: 87012	
Part #: <u>1350-636-614</u>	
Description: Skid tulse	
Welding Process: Tig[→ Mig[]	,
Base materiel: Alumini	
Current: AC[\rightarrow DC[]	•

TEST REQUIREMENTS AND RESULTS

Visual:	pass[-]	fail[]
Incomplete Penetration:	pass[]	fail[]
Incomplete Fusion:	pass[/	fail[]
Cracks:	pass[]	fail[]
Overlap (cold lap)	pass[]	fail[]
Undercut:	pass[-]	fail[]
Pin holes:	pass[]	fail[]
Porosity (surface):	pass[]	fail[]
Coloration:	pass[]	fail[]
Burn through:	pass[-]	fail[]

Qualifier Date of Test Coupon 2,57,23

Welder Date of Test Coupon 12-07-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld